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DART AEROSPACE LTD.	Work Order:	212.48
Description: Saddle Fitting, Fwd (Outboard/Inboard)	Part Number:	D2571/D2572
Drawing: D2571 Rev. D/D2572 Rev. D	Qty:	8 8
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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	HJ	04.07.13	8 8
2	MV	Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: B 26984	EP	04/08/03	8
3	MV	Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: B 20583	EP	04/08/03	8
4	MV	Fixturing W/O No. <u>W/A</u> Fixturing Inspection last completed 04/08/03 by EP	EP	04/08/03	8
5	MV	Program Batch No. <u>B 21248</u> Double check by: <u>SL</u>	EP	04/08/03	8
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets	EP	04/08/05	8
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	EP	04/08/05	8
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets	EP	04/08/05	8
9	MV	Machine keyway as per dwg D2571 & D2572	EP	04/08/05	8
10	MV	Deburr and remove all machining marks	EP	04/08/05	8
11	MV	Tumble for 20-minutes to remove sharp edges # 04.08.21	EP	04/08/05	8
12	QC1	Inspect all dimensions to dimension sheets	EP	04/08/05	8
13	QC7	Second inspection	EP	04.08.10	8
14	FP	Acid etch and alodine as per QSI 005 4.1	MM	04.08.10	8
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	MM	04.08.10	8
16	QC3	Inspect Powder Coat	2	04.08.11	8
17	ST	Identify and Stock.	CH	04/08/12	8
18	AC	Cost / Part <u>111.95</u> <u>89.60</u>	540	04-08-13	8
19	DC	Close W/O, 04.08.13 <u>83.88</u> Inspection Level 21	HJ	04.08.16	8

Rev	Date	Change	Revised By	Approved
G	01.04.27	Added D6101-007 & step 8	EC	
H	02.02.01	Added Inspection level 5 and Inspection Level 21	SM	
I	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2572	KJ RF	

RELEASED
02/10/15 RJD

